

Work Order ID 63605

Thursday, November 04, 2010 1:00:49 PM



Page 1

Item ID:	D3245-042	Accept		Setup	Start	
Revision ID:						
Item Name:	Access Panel Assembly				Stop	
Start Date:	11/4/2010	Start Qty:	4.00			
Required Date:	11/15/2010	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:		Date:	10/1/04	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3245	Rev B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245 be careful when countersinking...mat'l very thin								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

GS 11/01/11

GS 11/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63605

Thursday, November 04, 2010 1:00:49 PM



Page 2

Item ID: D3245-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 11/4/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/11/10 40

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/12

MR

11-01-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 1

Parent Item: D3245-042

Parent Item Name: Access Panel Assembly





Start Date: 11/4/2010

Required Date: 11/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2350-18-C3Y  RIGID RECEPTACLE		Purchased	No			110	Each	132.0000	8	32		5/11/11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST399				132					
					111581			37					
					19688			95					
D3245-2  Panel		Manufactured	No			110	Each	2.0000	1	4		5/10/12/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST233A				2					
					60078			2					
D3245-5  Door		Manufactured	No			110	Each	19.0000	1	4		5/10/12/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST233B				19					
					47591			7					
					47610			12					
MS20427M3-3  Rivet		Purchased	No			110	Each	1,816.000	16	64		5/11/01/11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST318				1816					
					115409			4					
					115589			1812					

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NOTE: Date & initial all entries -

Picklist Print

Thursday, November 04, 2010 1:00:53 PM

Page 2

Work Order ID: 63605

Parent Item: D3245-042

Parent Item Name: Access Panel Assembly

Start Date: 11/4/2010

Required Date: 11/15/2010

Start Qty: 4.00

Required Qty: 4.00

MS20615M3-3

Purchased

No

110

Each

51.0000

9

Rivet

Location

Loc Qty

Loc Code

ST323

51

111650

51



36
8/5/10/12/09
M111359 (9K)

M110985 (27K)

Thursday, November 04, 2010 1:00:53 PM

Shop Packet Print

Page 2

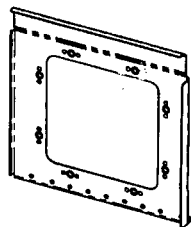
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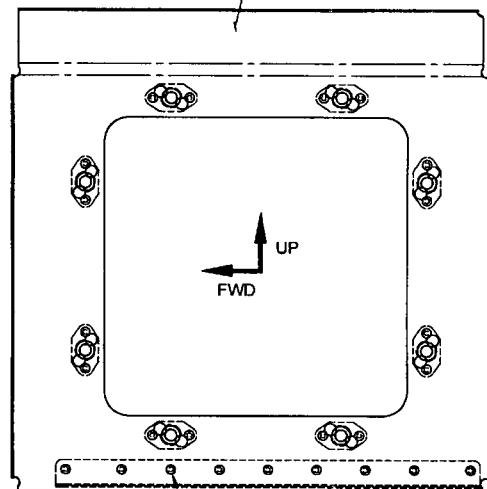
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D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

RELEASED
107-10-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 63605
13810-11-04

D3245-5
ANGLE PLATE

0.032
GAP

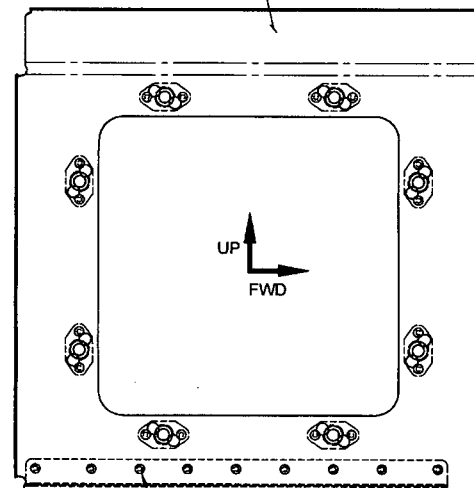
D3245-5
ANGLE PLATE

0.032
GAP

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.02		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3245	REV. B
TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2.5
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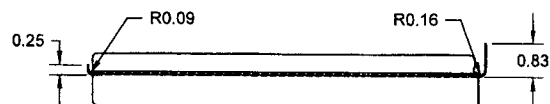
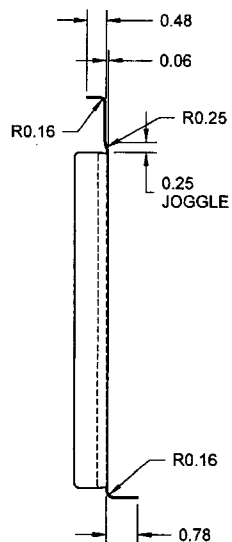
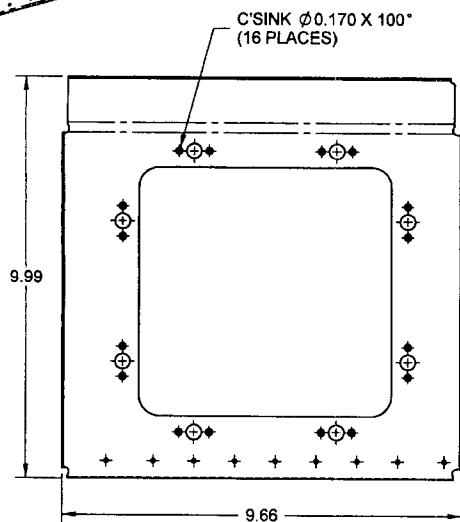
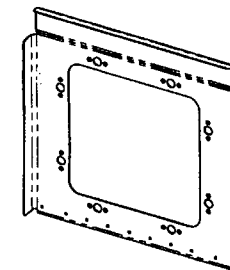
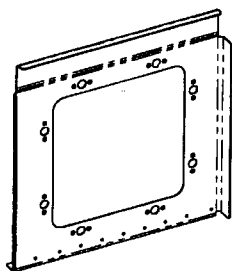
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

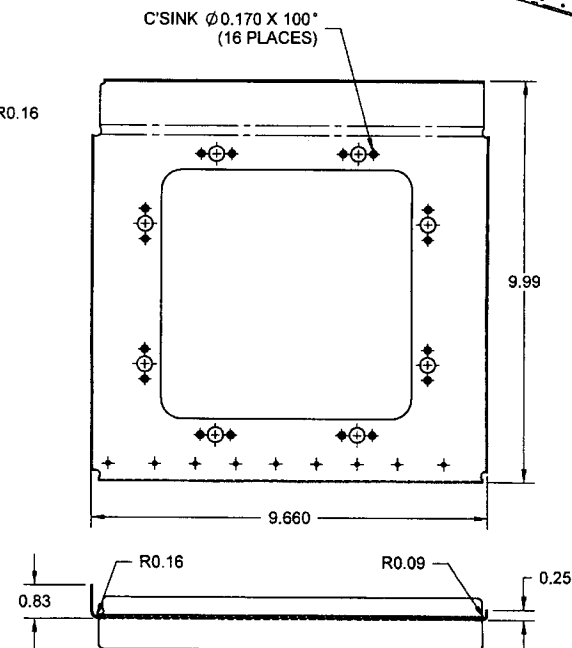
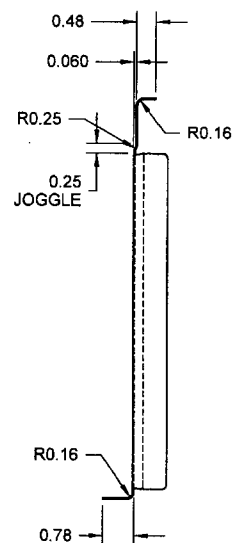
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3245-1 PANEL BEND DETAIL, LH



D3245-2 PANEL BEND DETAIL, RH

RELEASED
18-10-23

- NOTES:**
- 1) MATERIAL: MAKE FROM D3245-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 2 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:3
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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all 63605

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

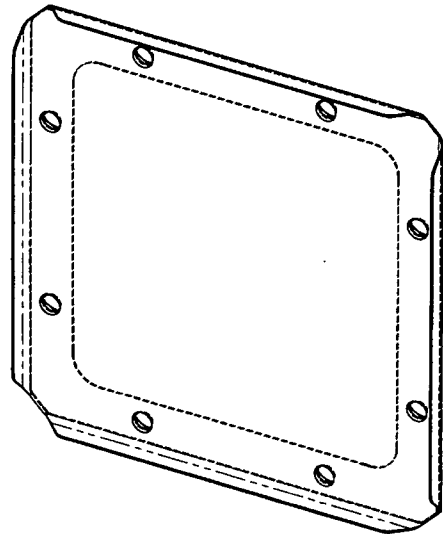
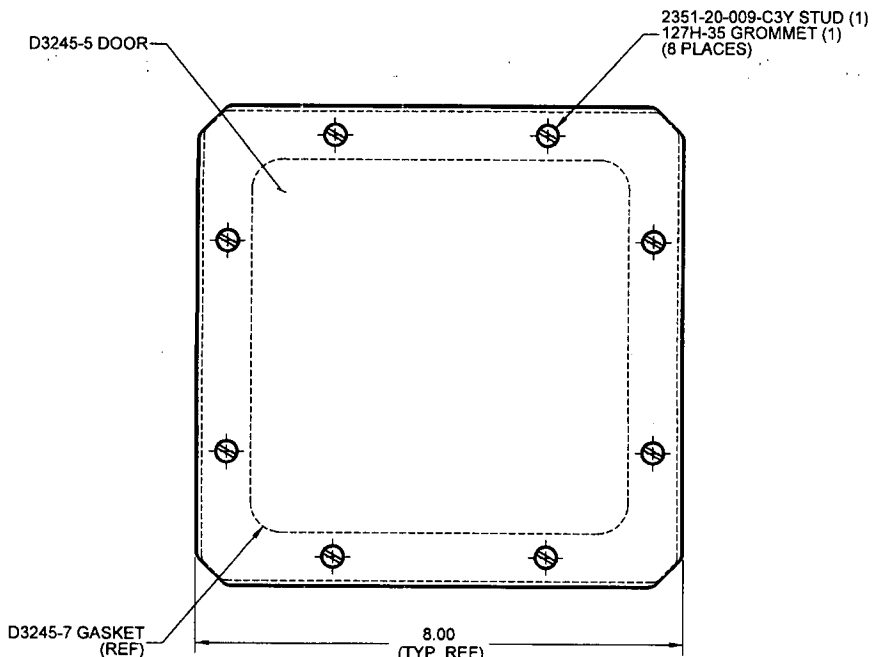
A

D

C

B

A



D3245-043 DOOR ASSEMBLY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
 - 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 - 9) WEIGHT: 0.73 lbs

W/O 63605

RELEASED
7/10/23

DESIGN	<i>TF</i>	DART AEROSPACE LTD
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO. D3245
MFG. APPR.	<i>PH</i>	REV. B
APPROVED	<i>PH</i>	SHEET 3 OF 7
DE APPR.	<i>PH</i>	TITLE ACCESS PANEL ASSEMBLY
DATE	07.10.02	SCALE 1:2

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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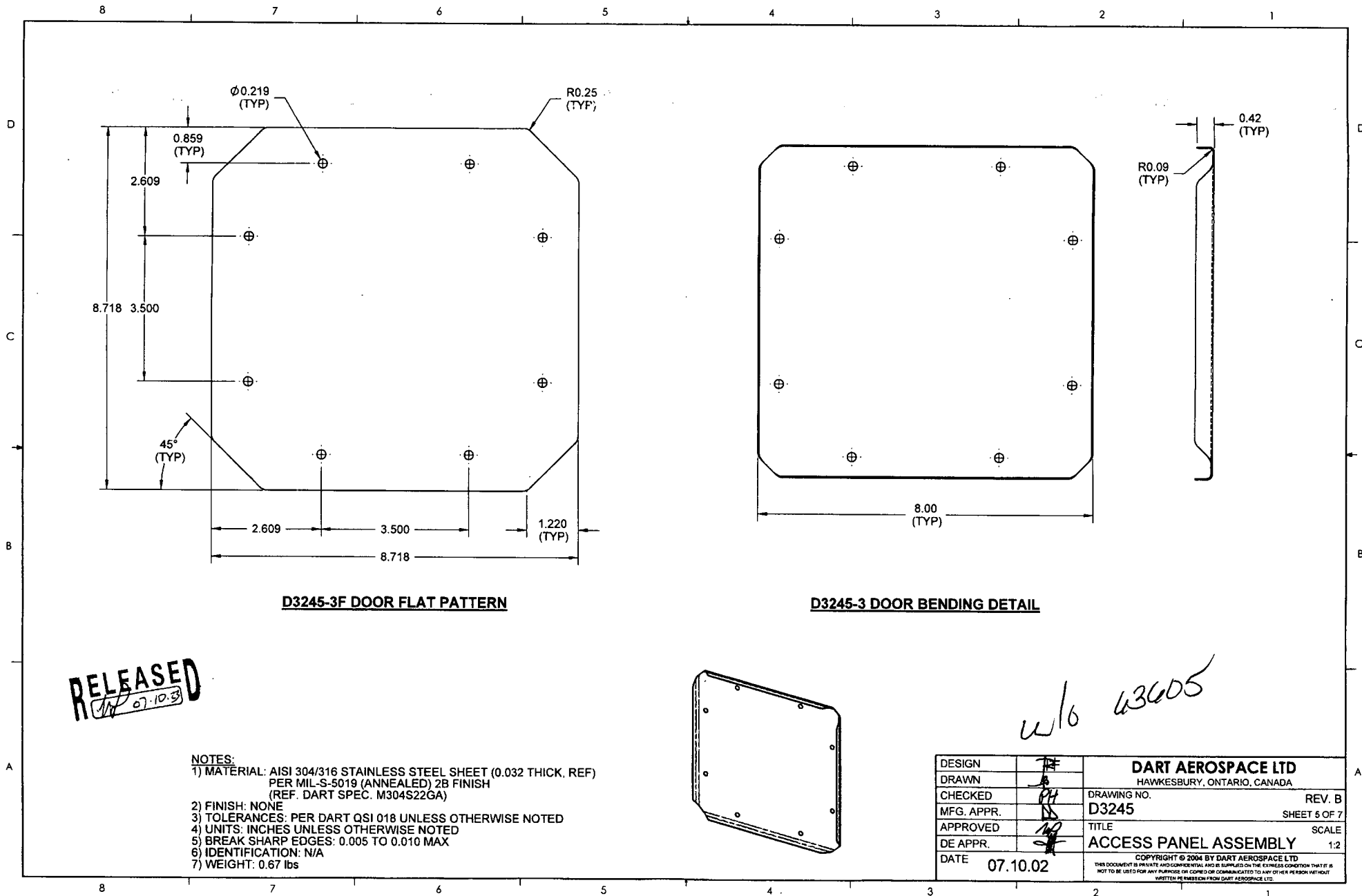
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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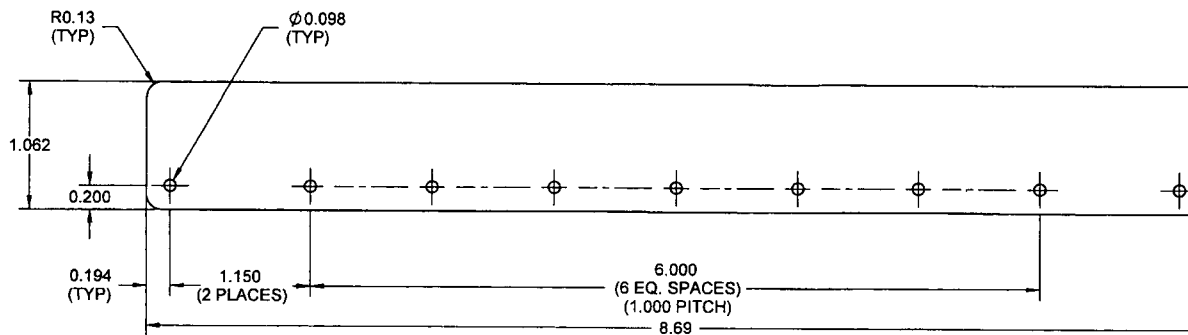
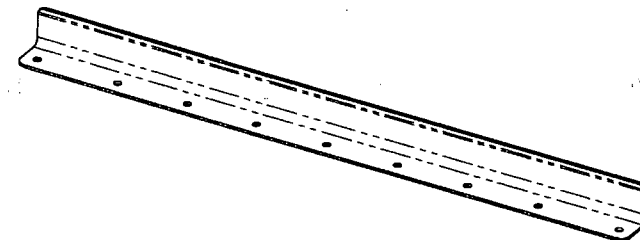
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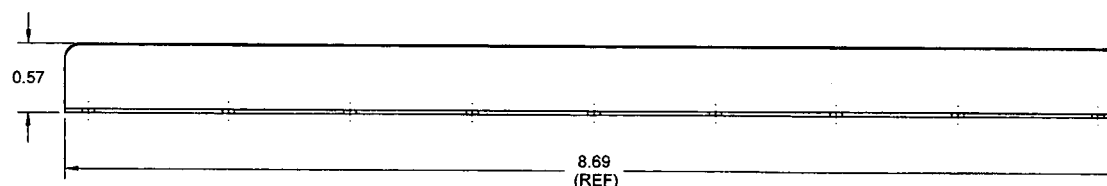
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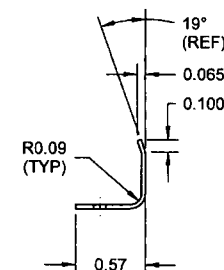
8 7 6 5 4 3 2 1



D3245-5F FLAT PATTERN



D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)



RELEASED
07.10.23

w/c 63605

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3245	SHEET 6 OF 7
APPROVED	RF	TITLE	SCALE
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8 7 6 5 4 3 2 1

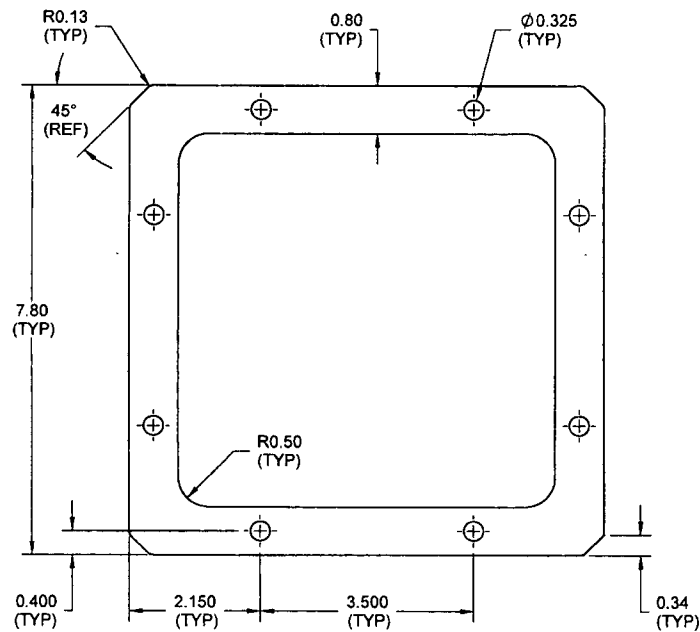
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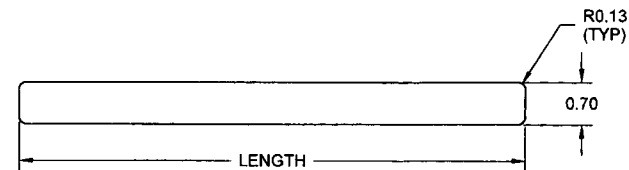
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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
07.10.02

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. D3245	REV. B
MFG. APPR.	<i>PH</i>		SHEET 7 OF 7
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	ACCESS PANEL ASSEMBLY	1:2
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w/o 63605

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